

Work Order ID 150119

Wednesday, August 24, 2016 11:35:34 AM

150119

Page 1

Item ID: 646.9711

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Blade

Start Date: 8/2/2016 Start Qty: 30.00

30

Cust Item ID:

Required Date: 8/26/2016 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: **DAS 21** Date **AUG 24 2016**

Tooling:

Date:

Run Start ***NR1***

QC: **9-89** Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
646.9700	D2

100 0.00

100

BAND SAW

Bandsaw

Memo

0.20

Jeaspa Bandsaw

Cut Blank at 4.625"

30 **6** **DAS 14 9-89 16/08/26**

110

0.13

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.80

HAAS CNC vertical machine #1

1-Machine per folio FB135

DWG REV: **D**

FOLIO REV: **42**

30 **0** **JK 1608-30**

2- deburr and break all sharp edges except otherwise noted

KNIFE EDGE MUST BE SHARPENED USING STONE, REMOVE ALL BURRS ON CUTTING EDGE

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Page 2

Item ID: 646.9711**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Item Name:** Blade**Stop*****NS2*****Start Date:** 8/2/2016 **Start Qty:** 30.00***30*****Cust Item ID:****Required Date:** 8/26/2016 **Req'd Qty:** 30.00***30*****Customer:****Reference:****Approvals:****Process Plan:** _____**Date:** _____**Tooling:** _____**Date:** _____**Run Start*****NR1*****QC:** _____**Date:** _____**SPC (Y/N):** _____**Date:** _____**Stop*****NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.05

Quality Control

30 0 SL
16-08-30

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.10

Quality Control

16/08/31

30 0 DAS
08
9-89

140

Outsource process - Heat Treat

0.00

140

Outsource1

Memo

1,199.95

Outsource process - Heat Treat

HEAT TREAT AS PER DWG, SEE NOTE #3

ISSUE P/O: 33523

30 SEP 02 2016 DAS
13
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor Approval Verification			
				QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

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Page 4

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Revision ID: Stop ***NS2***
Item Name: Blade
Start Date: 8/2/2016 Start Qty: 30.00 ***30*** Cust Item ID:
Required Date: 8/26/2016 Req'd Qty: 30.00 ***30*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control	QC14- Inspect Spray Paint Memo	0.00 0.05				<u>30</u>			DAS 38 9-89 SEP 30 2016
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: <u>5708A</u> Memo	0.00 0.05				<u>30</u>			DAS 6 9-89 SEP 30 2016
190 *190* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.50				<u>21</u>			DAS 21 9-89 OCT 03 2016

DAS
21
9-89
SEP 30 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : ☐																					

Picklist Print

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Work Order ID: 150119

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Parent Item: 646.9711

646 9711

Parent Item Name: Blade

Start Date: 8/2/2016

Required Date: 8/26/2016

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV:A NEW ISSUE 12/09/24 JFS VERIFY BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MSTEEL-A2- B0.500X1.250		Purchased	No			100	f	22.3935	0.386	12.18947			

MSTFFI -A2-B0 500X1 250

AISI A2 TOOL STEEL BAR, 0.500 X 1.250

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	0.3125	
M134172	0.3125	
MAT010	22.081	
M126438	5.452	
M127494	0.22	
M131783	4.409	
M133923	12	

DAS
14
9-89

16/08/26

12.19

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____																						
Misidentified ☐	☐	Past Due ☐																							



APICAL INDUSTRIES, INC.
dba DART AEROSPACE

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

ENGINEERING CHANGE NOTICE NO.

05360

SHEET 1 OF 1

DWG NO. 646.9700

REV: D

PREPARED BY J. BECKER

DATE: 03/24/16

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: CUTTER SUB ASSY

APPROVED BY: ENGR

MFG

QC

EFF.

CURRENT ORDER

REASON: REVISED DIMENSIONS

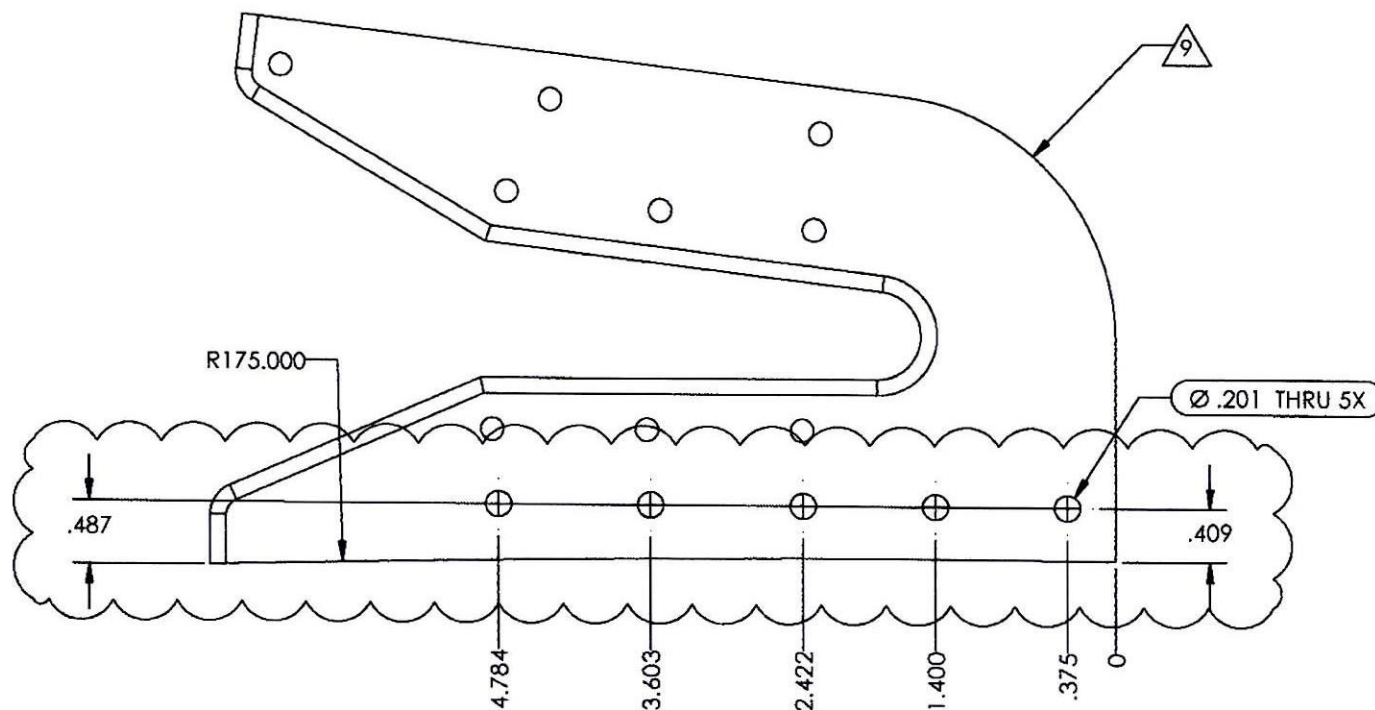
ECR:

N/A

ACTION ITEM:

1.

SHEET 7, ZONE C3 IS:



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. ISO119 M.J
160824

DOCUMENTS EFFECTED:

☐ PATTERN ☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

☐ YES ☒ NO

DART
AEROSPACEAPICAL INDUSTRIES, INC.
dba DART AEROSPACE

ENGINEERING CHANGE NOTICE NO.

05345

SHEET 1 OF 1

DWG NO. 646.9700

REV: D

PREPARED BY J. GARDINER

DATE: 03/15/16

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: CUTTER SUB ASSY

APPROVED BY:

ENGR.

MFG

QC

EFF.

CURRENT ORDER

TRANSACTION CODES (TC):

A-ADD
R-REVISEC-CREATE
D-DELETE

REASON: REVISED NOTES

ECR:

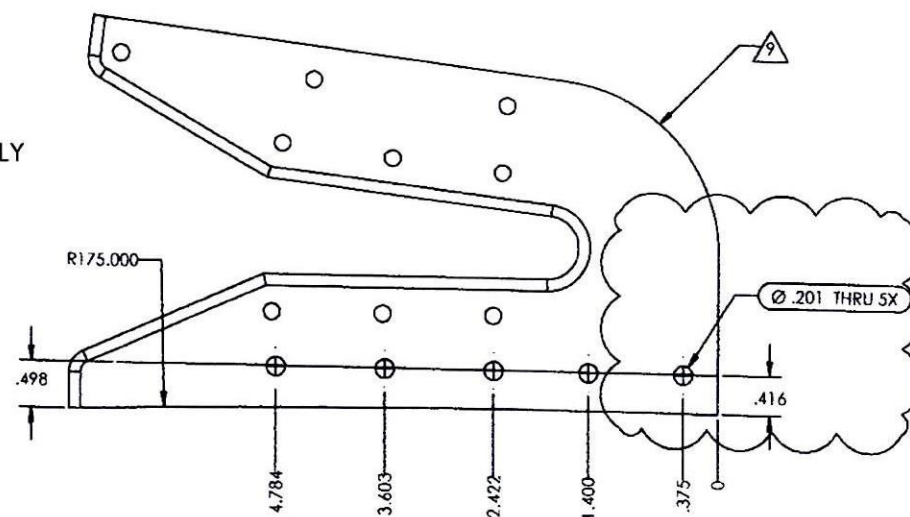
N/A

ACTION ITEM:
1.**SHEET 1, ZONE A6 IS:**

NOTES:

IS

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- 2 FINISH IAW MPP-172 SECTION 2.1, 3.3 & 4.3.
- 3 MATERIAL: A152 TOOL STEEL
CONDITION: ANNEALED
POST PROCESS: HEAT TREAT TO 58-62 Rc ROCKWELL HARDNESS
- 4 FINISH: PRIME IAW MPP-172 SECTION 3.3; 1-2 MIL MAX
5. DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED
6. IDENTIFY IAW MPP-120
- 7 APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 2 UPON ASSEMBLY
- 8 CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE
- 9 ALL DIMENSIONS NOT SPECIFIED ARE CONTROLLED BY 646.9710.

SHEET 7, ZONE C5 IS:

DOCUMENTS EFFECTED:

☐ PATTERN ☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

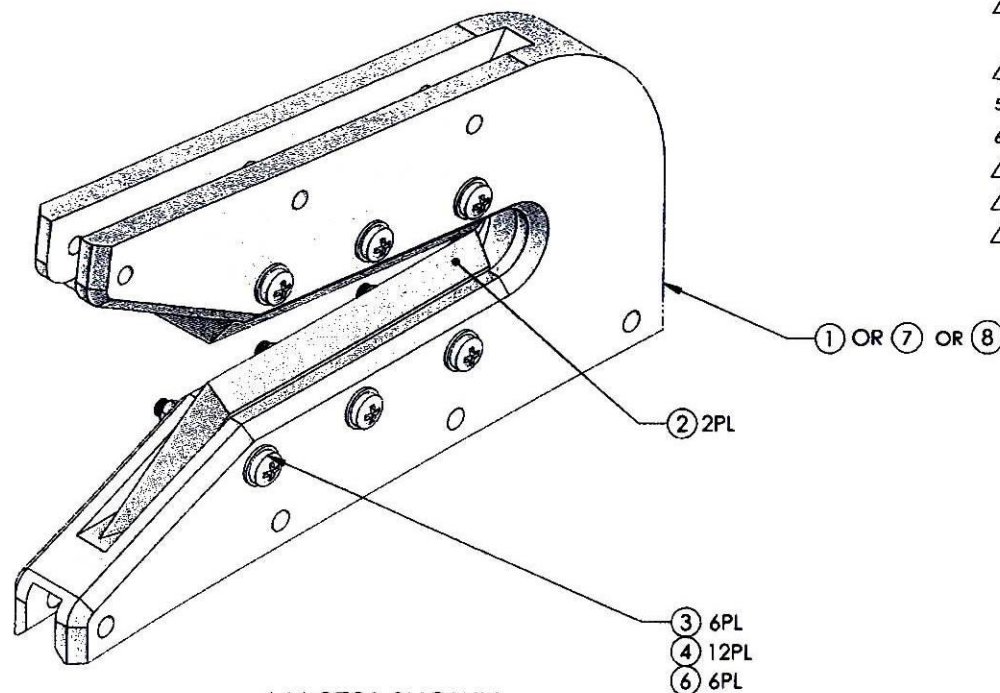
☐ YES ☒ NO

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#EVS0HS				
REV	DESCRIPTION	DATE	APPROVED	
	LAST PROTOTYPE REVISION: #92		INC	
INC	MEMO RELEASE	02/27/09	P. BRAYVO	
	INCORPORATED ECH 00274, 00288, 00912	04/06/10	P. BRAYVO	
B	INCORPORATED FCN 00847	07/03/10	P. BRAYVO	
C	INCORPORATED ECH 94039	06/08/13	P. BRAYVO	
D	INCORPORATED LD ECH 94529	02/24/16	P. BRAYVO	

NOTES:

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- 2 FINISH IAW MPP-172 SECTION 3.3 & 4.3.
- 3 MATERIAL: AISI A2 TOOL STEEL
CONDITION: ANNEALED
POST PROCESS: HEAT TREAT TO 58-62 Rc ROCKWELL HARDNESS
- 4 FINISH: PRIME IAW MPP-172 SECTION 3.3; 1-2 MIL MAX
5. DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED
6. IDENTIFY IAW MPP-120
- 7 APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 2 UPON ASSEMBLY
- 8 CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE
- 9 ALL DIMENSIONS NOT SPECIFIED ARE CONTROLLED BY 646.9710.



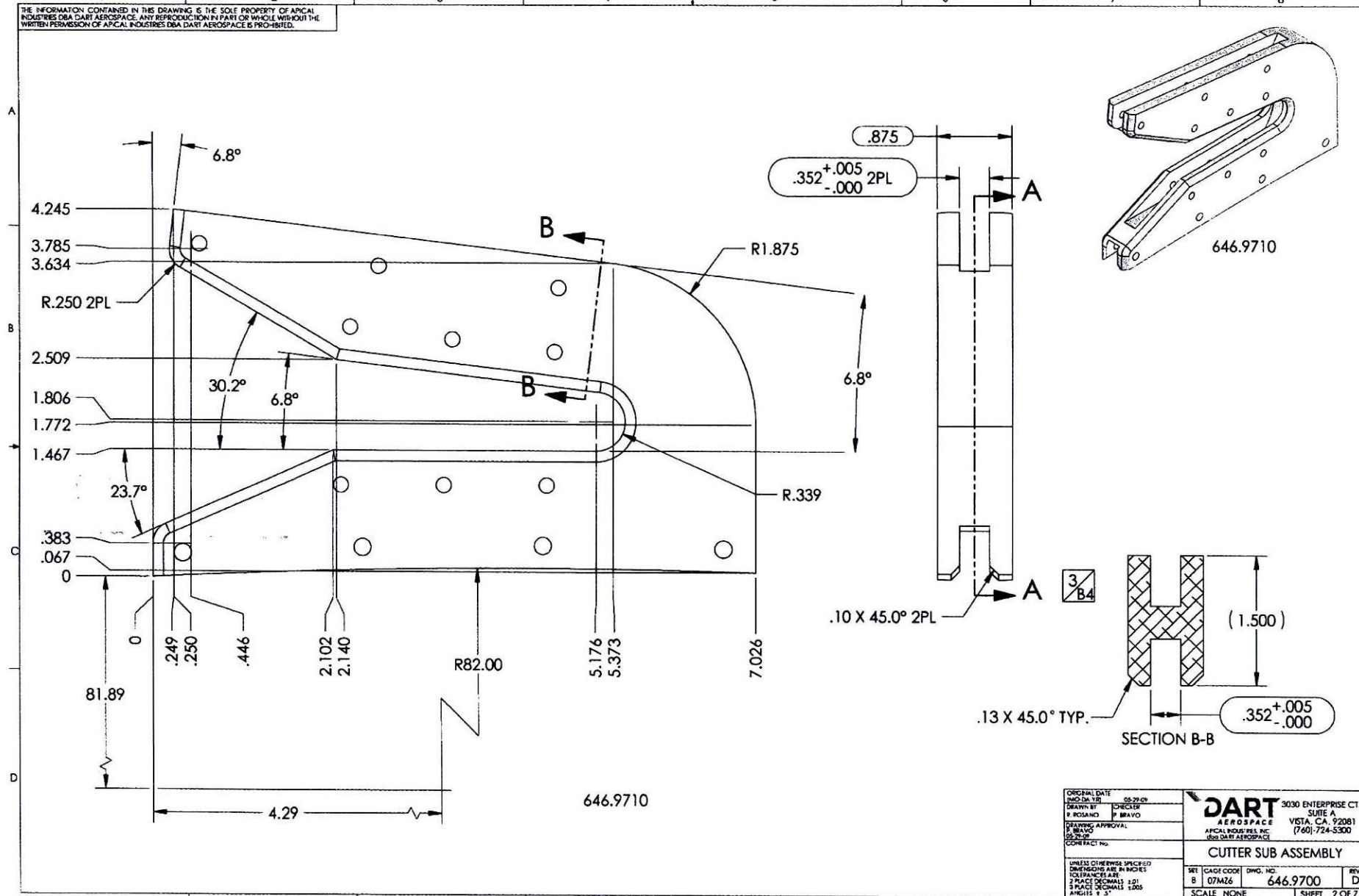
646.9701 SHOWN
646.9702 & 646.9703 TYP

UNINCORPORATED ECN(s)

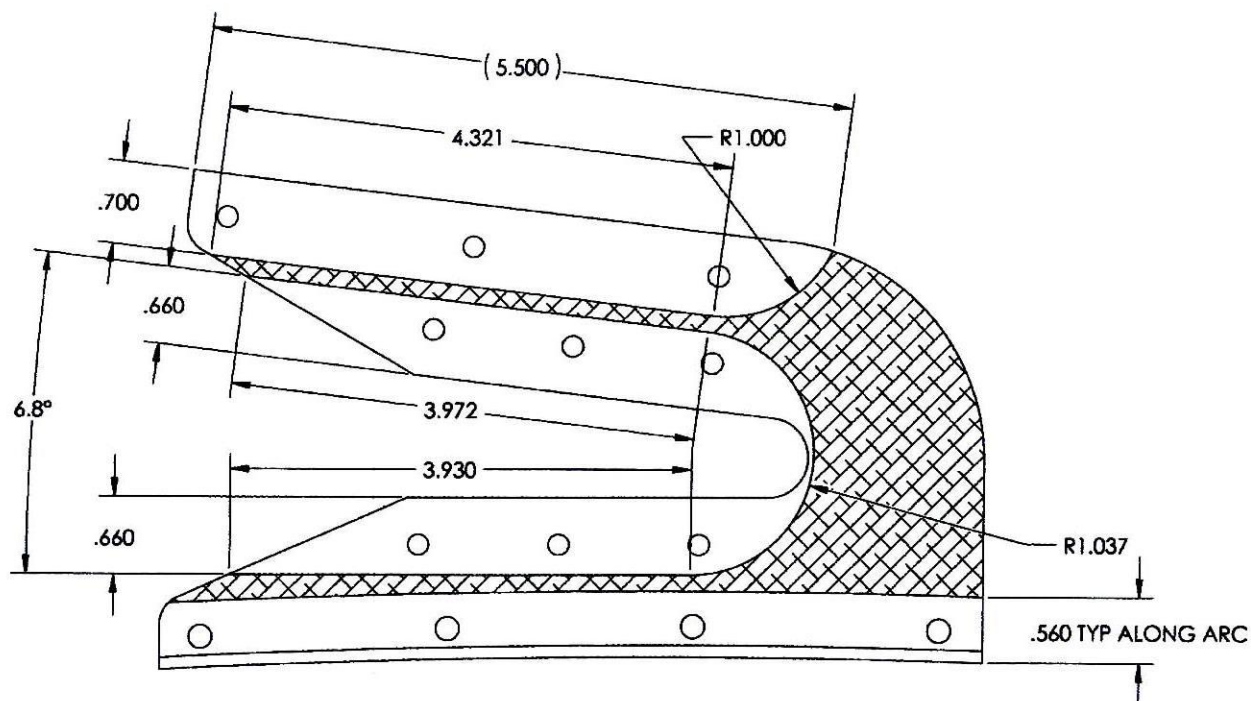
05345, 05360

1			8	646.9713	BODY	△	△△
	1		7	646.9712	BODY	△	△△
6	6	6	6	601.1541	LOCKNUT	MS2104708	
A/R	A/R	A/R	5	601.2045	RTV. LOCTITE S98		
12	12	12	4	601.2764	WASHER	MS1147HB2P	
6	6	6	3	601.2765	SCREW	MS27009-0619	
2	2	2	2	646.9711	BLADE	△	△
		1	1	646.9710	BODY		△
X				646.9703	CUTTER SUB ASSY		
	X			646.9702	CUTTER SUB ASSY		
		X		646.9701	CUTTER SUB ASSY		
9703	9702	9701	FIND #	PART #	DESCRIPTION	MATL	SPEC.
QTY		PARTS LIST					
NEXT ASSY (S)				 DART 3030 ENTERPRISE CT. SUITE A VISTA, CA 92081 (760)-724-5300 APCAL AEROSPACE INC. 9800 DART INDUSTRIAL			
646.9600							
ORIGINAL DATE 05-28-09 BY: CAVITE P. ROSAND P. BRAVO DRAWN BY APPROVED APPROVAL P. BRAVO CONTRACT NO.							
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 7 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 FRACTIONS ±.01							
				CATER SUB ASSEMBLY SEE CAGE CODE 07046 B 07046 SCALE NONE QTY 1 OF 2			

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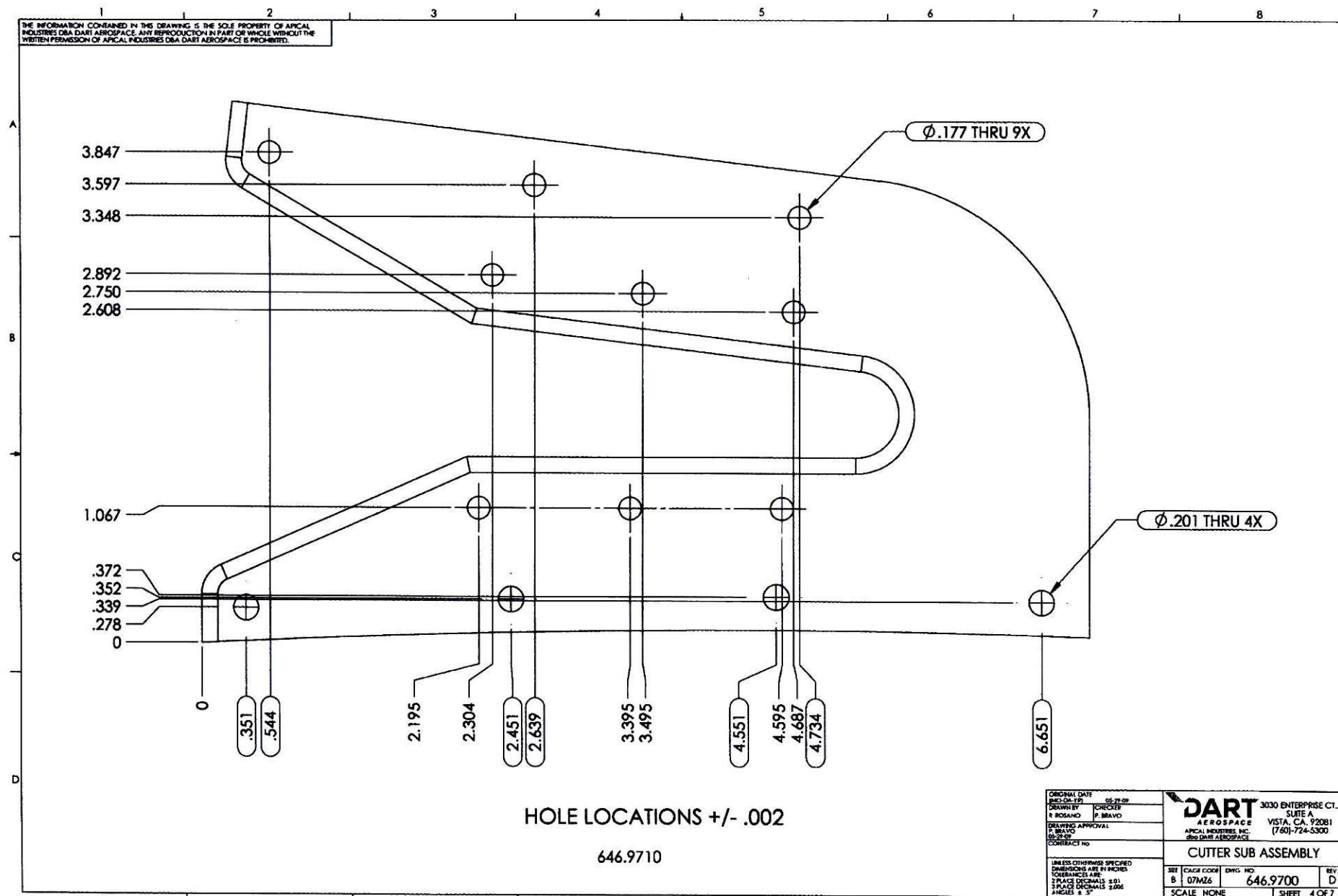


SECTION A-A $\frac{2}{C6}$

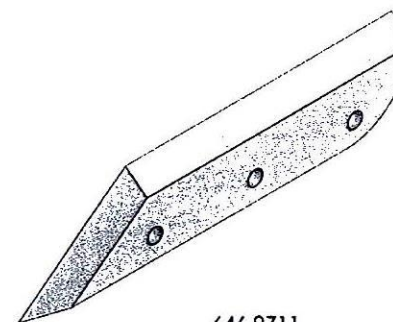
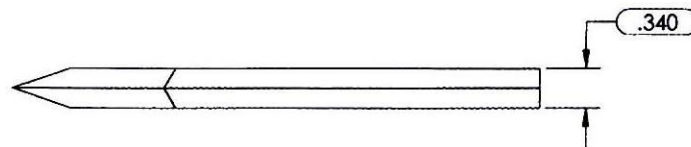
646.9710

ORIGINAL DATE 06-20-09		3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760)-724-5300	
DRAWN BY K. BORARO	CHECKED P. BRAVO	APICAL INDUSTRIES INC. DBA DART AEROSPACE	
DRAWING APPROVAL P. BRAVO		CUTTER SUB ASSEMBLY	
CONTRACT NO.		REV B	REV D
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		CAGE CODE 07M26	DWG. NO. 646.9700
SCALE NONE		SHEET 3 OF 7	

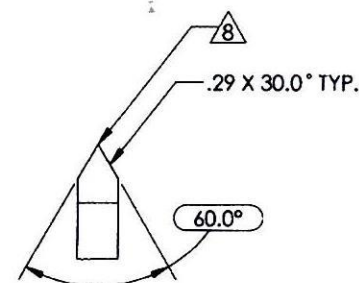
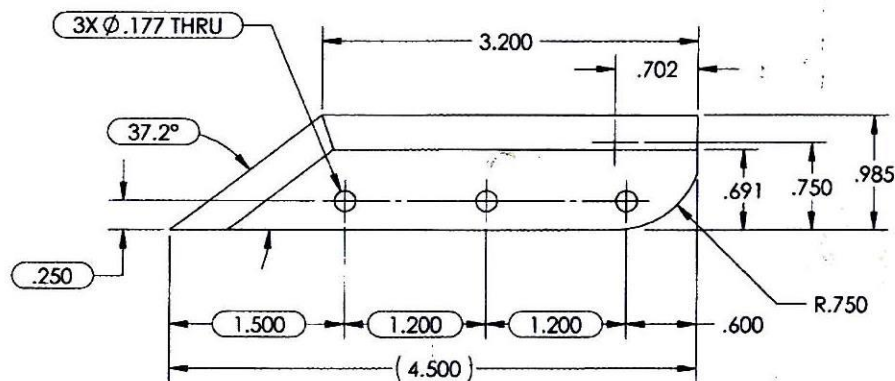
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES DBA DART AEROSPACE. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES DBA DART AEROSPACE IS PROHIBITED.



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646.9711

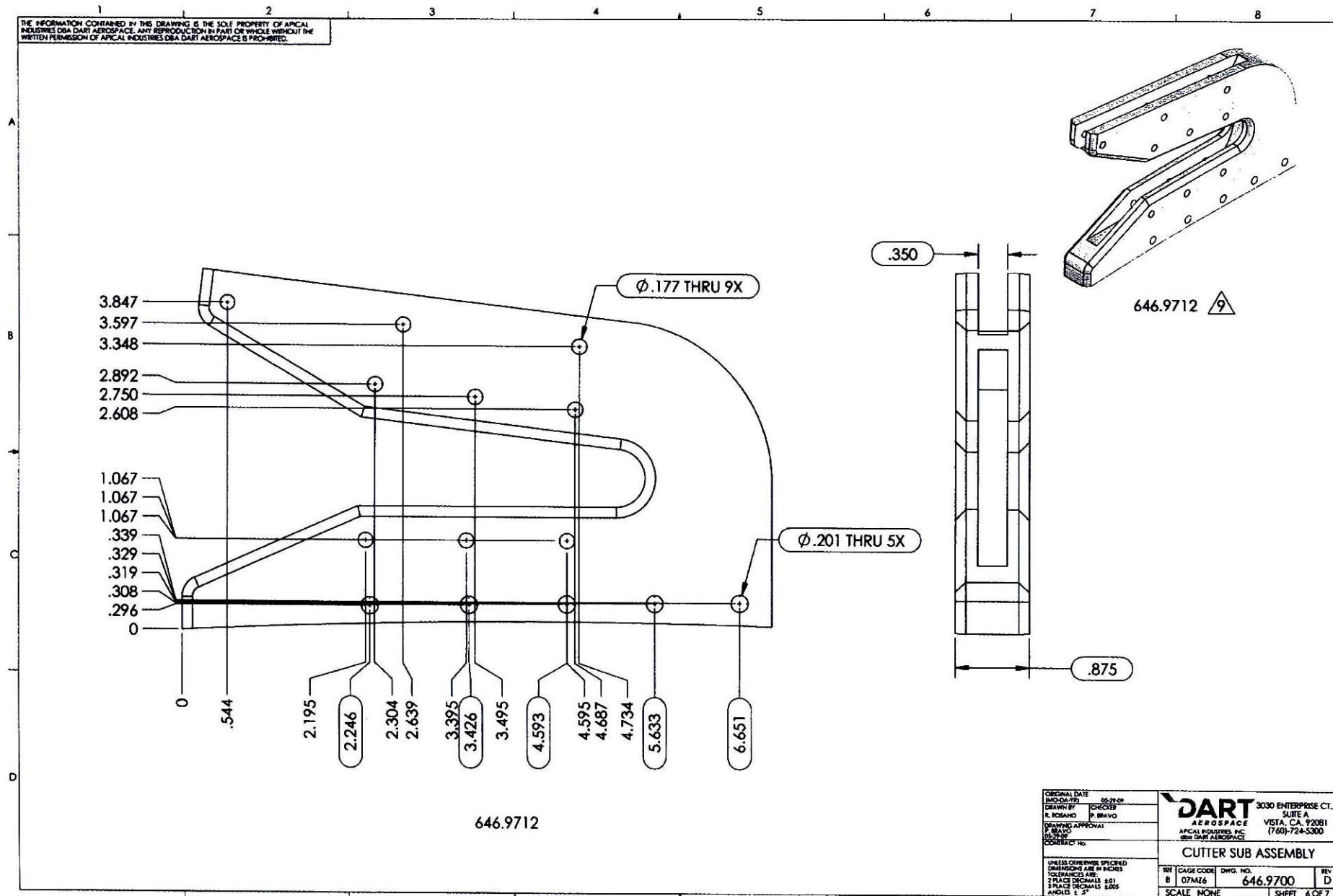


646.9711

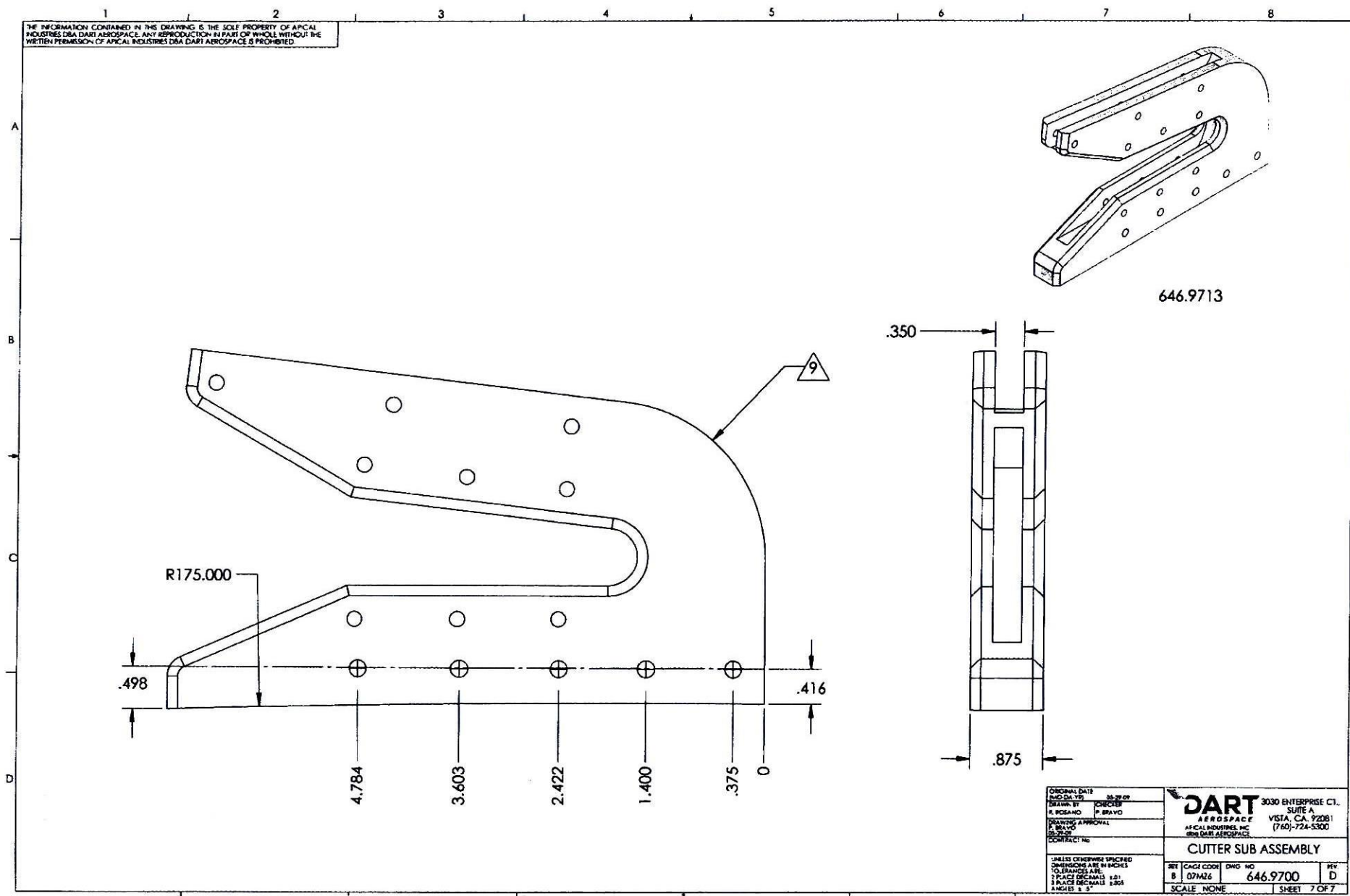
ORIGINAL DATE 2002-04-10		CA-79-09									
DRAWN BY P. ROSANO		CHECKED P. BRAVO									
DESIGNED BY P. BRAVO		APPROVED BY P. BRAVO									
CONTRACT NO.		CUTTER SUB ASSEMBLY									
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		<table border="1"> <tr> <td>REV.</td> <td>CAGE CODE</td> <td>DWG. NO.</td> <td>REV.</td> </tr> <tr> <td>B</td> <td>D7MZ6</td> <td>646.9700</td> <td>D</td> </tr> </table>		REV.	CAGE CODE	DWG. NO.	REV.	B	D7MZ6	646.9700	D
REV.	CAGE CODE	DWG. NO.	REV.								
B	D7MZ6	646.9700	D								
SCALE: NONE		SHEET 5 OF 7									

DART 3030 ENTERPRISE CT.
AEROSPACE SUITE A
VISTA, CA. 92081
APICAL INDUSTRIES INC.
DBA DART AEROSPACE (760) 724-5300

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ORIGINAL DATE 08-20-09 DWG. NO. 646.9700		3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300			
DRAWN BY A. ROSS-MO	CHECKED P. BRAYO			DART AEROSPACE APCAL INDUSTRIES, INC. DBA DART AEROSPACE	
DRAWING APPROVAL P. BRAYO				CUTTER SUB ASSEMBLY	
CONTRACT NO.		REV B	CAGE CODE 07M26	DWG NO. 646.9700	REV. D
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DIMENSIONS ARE IN INCHES 3 PLACE DECIMALS 1.21 1 PLACE DECIMALS 2.50 INCHES & 5"		SCALE NONE	SHEET 7 OF 7		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO33523**

Purchase Order Date 9/2/2016

PO Print Date 9/2/2016

Page Number 2 of 2

Order From :

VC-MET004

Ship To : DART AEROSPACE LTD

METCOR INC.
560 BOUL. ARTHUR SAUVE
SAINT-EUSTACHE, QC J7R 5A8
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

450 473 1884

Ship To Contact

Ship To Phone

Ship Via:

FedEx Economy collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Total: **\$0.00**

3 150119

646.9711 blade

9/16/2016

Yes

9/16/2016

30.00

\$0.00

\$0.00

FINISH: HEAT TREAT TO 58-62 RC
ROCKWELL HARDNESS

PART ARE MADE FROM AISI A2 TOOL STEEL

PLEASE NOTE: DETAIL C OF C REQUIRED

8/16-9-15

Line Total: **\$0.00**

4 71401-45

procurement quality clauses

9/16/2016

No

9/16/2016

1.00

\$0.00

\$0.00

Procurement Quality Clauses

A005 right of entry

A012 chemical and physical test report

A020 non-destructive test/inspection identification

A021 dart aerospace processing

A024 process certifications

A026 certification of material conformance

Line Total: **\$0.00**

PO Total: **\$0.00**

CL

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 9/2/2016

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
313553	1	113840

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À /Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
33523		A2	2016/9/7	CLIENT
QUANTITÉ Quantity	No. PIÈCE / Part No.	NOM DE LA PIÈCE / Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
48	646.3314			13,44

(8) 646.3314 149314
(10) 646.9711 148546
(30) 646.9711 150119 ✓

1 VALISE NOIRE

SP/6-9-14

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
	1	1 VALISE NOIRE

CERTIFICAT

EMPAQUETAGE Packing	
------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 48
POIDS EXPÉDIÉ / Weight Shipped : 13,44
QUANTITÉ RESTANTE / Quantity Remaining : 0
POIDS RESTANT / Weight Remaining : 0,00

RECEIVED
108

CERTIFICAT

QUANTITÉ EXPÉDIÉE /Quantity Shipped:	48
POIDS EXPÉDIÉ / Weight Shipped :	13,44

Signature:

Date:

EXPÉDIÉ LE / Shipped On : 2016/09/12

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
313553	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
33523	N/A	A2		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications				
VAC HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results	
HARDNESS	58 - 62 HRC	7	60 - 61 HRC	
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
48	13.44	646.3314 (8) 646.3314 149314 (10) 646.9711 148546 (30) 646.9711 150119 <u>1 VALISE NOIRE</u>		

COMMENTAIRES / comments

VAC HARDEN 1800F, 1:30 HR
DOUBLE TEMPER 400F, 2 HRS

Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification. All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

APPROUVÉ par / Approved by:

 Isabel Otero
QA Technician

 DATE: 2016-09-12